

Date: Thursday, 04/09/2008 9:01:42 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 41795		
Estimate Number	: 11181		
P.O. Number	:	Part Number	: D32941
This Issue	: 04/09/2008 S.O. No. :	Drawing Number	: D3294 PROTO E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: PROTO E
Previous Run	: 40544	Material	:
Written By	:	Due Date	: 11/09/2008 Qty:
Checked & Approved By	: <u>JUL 08.9.04</u>		
Comment	: Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM Est Rev:C 08-07-16 Redesign part DD verified by:EC		

2 ONLY
 at Rev A1

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 2.1072 sf(s)/Unit Total : 25.2869 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3294-1
 Batch: 109424 B 8-10-21

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3294
 Dwg Rev: A B 8-10-21
 Prog Rev: A
 2-Deburr if necessary B 8-10-21

2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/10/22 42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 9:01:42 AM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

u/y

Done at step #22

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Form as per Dwg D3294

50/6/22

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/27 x2

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-h 08/10/28

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M10S642

(2x)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:20
320 OF
7:30

M-h 08/10/31

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FD 08/10/31 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP . 41359

SS 08/10/31 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 9:01:42 AM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

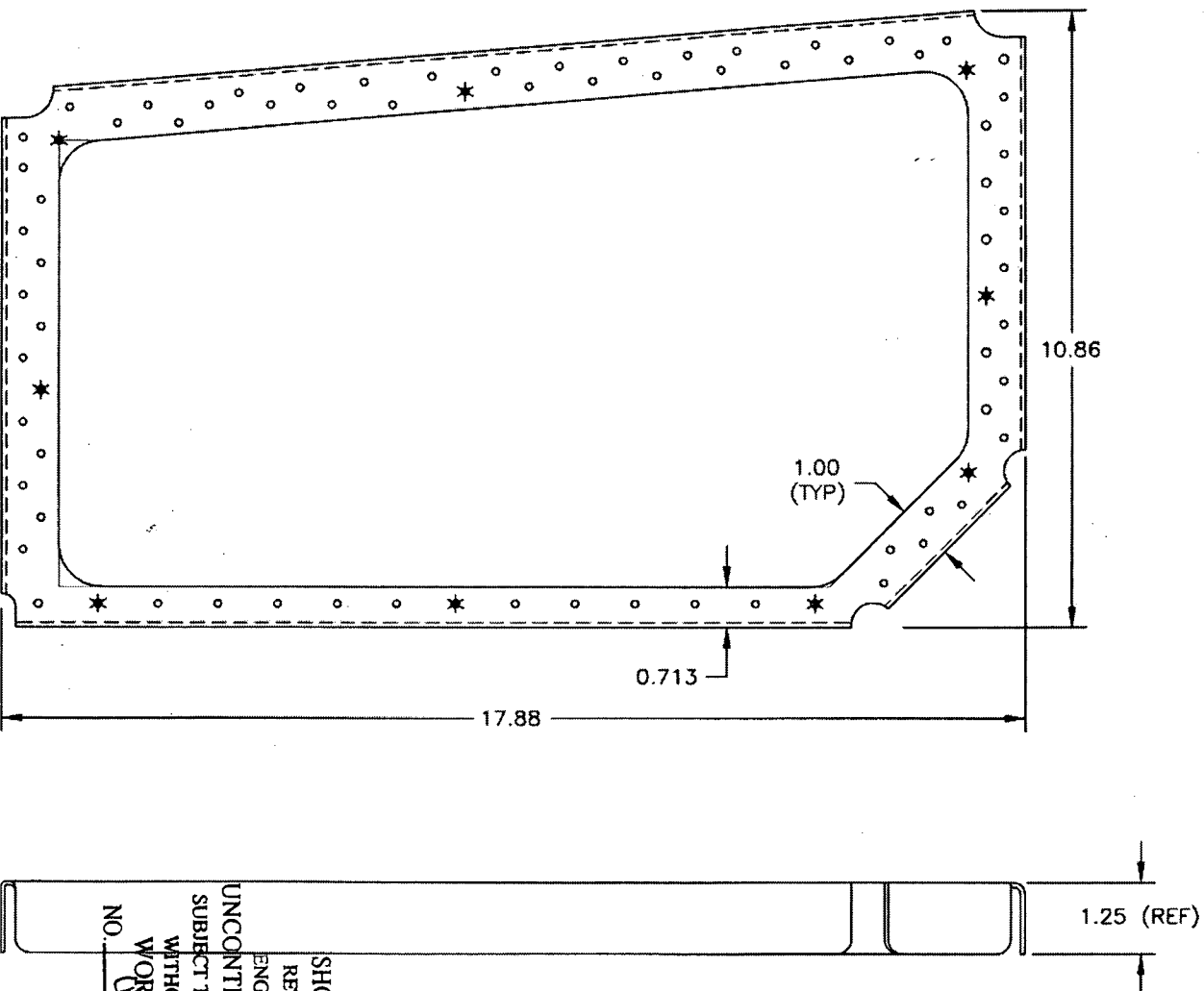


DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. A
				D3294	SHEET 1 OF 2
DATE	04.06.28			TITLE	SCALE
				BRACKET	1:3
A	04.06.28			NEW ISSUE	
A1	<i>CP</i>	05.06.13	12.57	WAS 1303, AS MANUFACTURED	

RELEASED
04.07.12

D3294-1 BRACKET

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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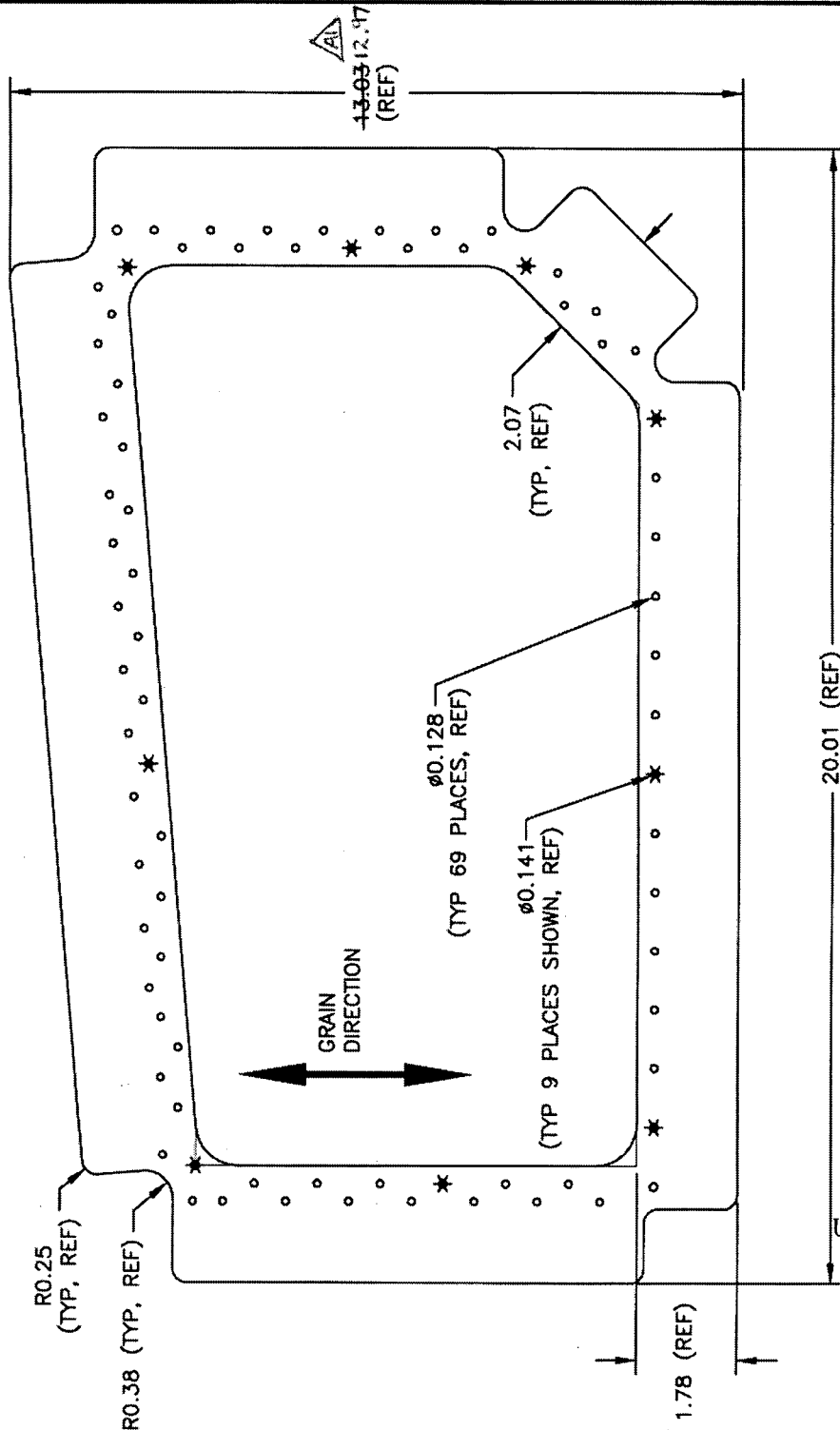
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3294	REV. A SHEET 2 OF 2
DATE 04.06.28	TITLE BRACKET		SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED
R 04.07.12 #



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